Date:

Wednesday, 26/11/2008 12:45:45 PM

User:

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 43743

Estimate Number

: 11175

P.O. Number

Prsht Rev.

First Issue

Previous Run

This Issue : 26/11/2008

: NC

: // : 41890

S.O. No. :

Type : MACHINED PARTS **Part Number**

Drawing Name

: D22825

Drawing Number Project Number

: D2282 REV E : N/A

: E

Drawing Revision Material

Due Date

: 10/12/2008

: TUBE

Qty:

50 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:A

EstRev:B

Removed from 9 Digit

05-12-02 JLM Now on Doosan Lathe 08-06-05 JLM

Verified By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304 SS Roundbar .750

1.0

2.0

M304RO750

9.833

0.1891 f(s)/Unit Total:

Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)

Batch M110166

DOOSAN LATHE

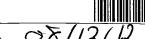


Comment: DOOSAN LATHE

1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1



PACKAGING RESOURCE



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Page 1

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP		PROCEDURE CHANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Category:	NCR:	Yes I	No DQ	\ :	Date: _	
	R	esolution:	Disposition:	QA: N	C Clo	sed:		Qty Chief Eng / QC Inspec	
			WORK OPPER NON COM	EODMANIOE /	IOD				

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)						
		Description of NC	Corrective Action Section B			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
	. [
		- A-2									
		<u></u>									
								į			

NOTE: Date & initial all entries

Date:

Wednesday, 26/11/2008 12:45:45 PM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 43743

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15

Job Completion



U 8.12.15

Dart Aerospace Ltd

	-									
W/O:			WC	RK ORDER CHANG	ES					
DATE STEP		PR	OCEDURE CHAI	NGE	By Date Qty Approval Chief Eng / Prod Mgr					Approval QC Inspector
										i
i					i					
Part No):	PAR #:	Fault Cate	jory:	NC	R: Yes N	10 DQ	A:	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR))			
DATE	STEP	Description of NC			ion B		Verification		Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	·	Sign & Date	Section	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43743
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					3 .	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.165				
R0.063	+/-0.010	R063	-	_		
0.063	+/-0.010	-060				
0.125	+/-0.010	.123				
0.090 x 45°	+/-0.010	087 x43°			-	- ·
R0.350	+0.010/-0.000	R 350				· · · · · · · · · · · · · · · · · · ·
0.158	+/-0.010	.158			· · · · · · · · · · · · · · · · · · ·	
Ø0.386	+0.005/-0.000	0.388	//			
Ø0.700	+/-0.010	Ø. 700				

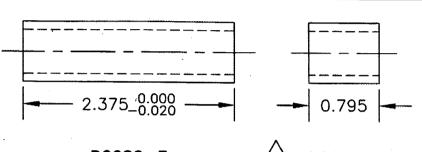
Measured by: 5	Audited by:	Ref ,	Prototype Approval:	N/A
Date: 6/12/12	Date:	08/12/1	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Dimensions & tolerances changed	KJ/JLM	
С	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	77
		20.700 difficion dadoa		كافيو

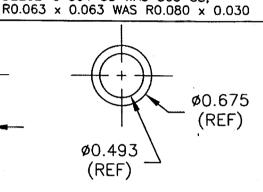
DAVIT

	DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECK	P	APPROVED I	D2282 REET 1 OF 2
١	DATE			TITLE SCALE
	05.0	6.07		HANDLE TUBES 1:1
	Α		94.10.14	NEW ISSUE
	В		95.03.23	RE-DESIGN
	С		97.10.20	CORRECTED NUMBERING SCHEME
	D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750

BELVASE BOS/09/16



Ε



D2282-5 304 SS WAS 303 SS:

D2282-3



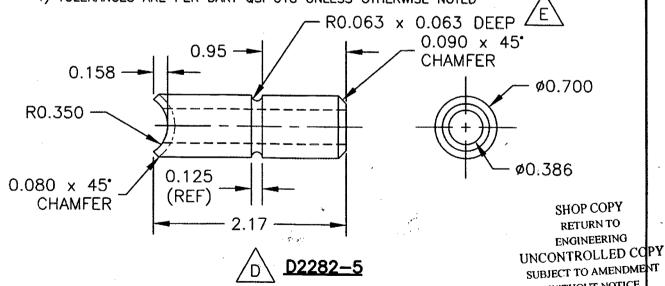
D2282-7

05.06.07

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

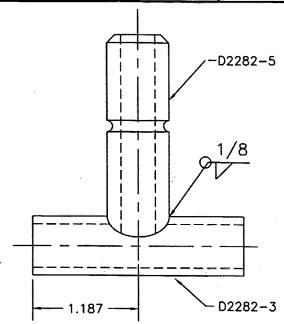
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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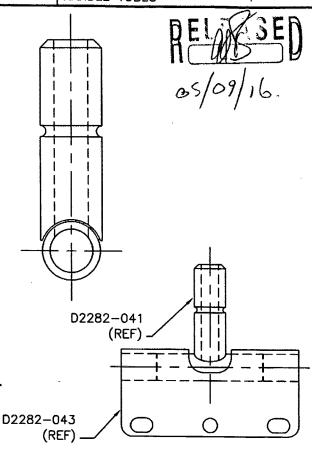
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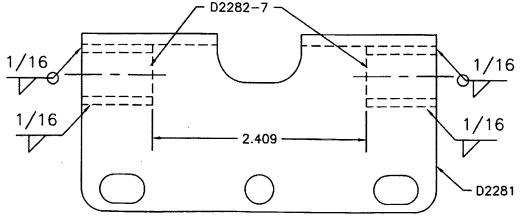
DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
'U'	IUND	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	. 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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